

Work Order ID 56087

February 10, 2010 11:22:06 AM

Page 1

Item ID: D212-725-1-207

Accept

Setup Start

Revision ID:

Stop

Item Name: Center Front Panel

Start Date: 2/10/10 Start Qty: 1.00

Cust Item ID:

Required Date: 2/17/10 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D212-725-1

PG1

100

0.00

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D212-725-1-205

Dwg Rev:

Prog Rev:

2-Deburr if necessary

10-2-11

①

110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

10-2-11

PRELIMINARY ISSUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 56087**

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Page 2

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Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC8- Inspect parts - second check

0.00

S 10/02/11

QC

Memo

0.00

(70)

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00

H 10/02/11

HandFinish

Memo

0.00

(X1)

2

Hand Finishing

140

Spray Painting per QSI005 4.2

0.00

SprayPaint

Memo

0.00

m

10-02-16

(10-02-16)

(10-02-16)

Spray Painting

PAINT FLAT BLACK AS PER DWG

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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Page 3

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Customer:

Reference:

Run Start

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

~~QC~~ Inspect Part Finish

0.00

8.06/16



QC

QC14  
S

Memo

0.00

Quality Control

160

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00

SENT TO HARVEY  
AT EAGLE UNDER  
POS. RECALL  
10/02/16

Packaging

Memo

0.00

10-2-16

30

Packaging

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

POSITIVE RECALL

EFFECTIVE 10.02.10 AUTH W

RELEASED \_\_\_\_\_ DATE \_\_\_\_\_

ME  
10-2-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

February 10, 2010 11:22:09 AM

Work Order ID: 56087



Parent Item: D212-725-1-207



Parent Item Name: Center Front Panel

Start Date: 2/10/10

Required Date: 2/17/10

Comments: IPP RevA: new issue DD 10.02.10 verified by:JLM

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No			100	sf	226.2623	1.6000			



18-10-2-11

6061-T6 .125 Sheet

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	226.2623	
110062	1.85	
111642	19.592	
112476	32	
112567	18.7403	
113424	58.08	
113608	96	

①

113424

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> S6087
<b>Description:</b> CENTER FRONT PANEL		<b>Part Number:</b> D212-725-1-207
<b>Inspection Dwg:</b> D212-725-1-207	<b>Rev:</b> PRE-EM P(7)	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .180	+ .005 - .001	.184	Ø			
Ø .635	+ .008 - .001	.636	Ø			
Ø 1.965	+ .012 - .001	1.966	✓			
1.09	± .030	1.097	✓			
2.29	± .030	2.287	✓			
4.11	± .030	4.115	Ø			
10.86	± .030	10.859	Ø			
15.40	± .030	15.40	Ø			
.70	± .030	.709	✓			
6.45	± .030	6.455	✓			
7.19	± .030	7.182	Ø			
7.66	± .030	7.667	✓			
8.18	± .030	8.184	✓			
8.73	± .030	8.737	Ø			
9.19	± .030	9.186	Ø			
10.45	± .030	10.451	Ø			
12.70	± .030	12.70	Ø			
14.20	± .030	14.20	✓			
2.00	± .030	2.00	✓			
4.03	± .030	4.032	Ø			
4.25	± .030	4.247	Ø			
5.50	± .030	5.509	Ø			
6.13	± .030	6.133	Ø			

<b>Measured by:</b> PB	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 10-2-11	<b>Date:</b> 10/2/11	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

D212-724-1-207

<input checked="" type="checkbox"/>	First Article	<input type="checkbox"/>	Prototype
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Measured by:	KB	Audited by:	S	Prototype Approval:	N/A
Date:	10-2-11	Date:	10/02/11	Date:	N/A

H:\FORMS\Quality Assurance\approved QA\FAI revD

